

Date: Thursday, 5/4/2006 11:12:53 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY  
 Job Number : 26945  
 Estimate Number : 11745  
 P.O. Number : N/A Part Number : D3394043  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3394 PRELIMINARY  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : 26185 Material : N/A  
 Due Date : 5/18/2006 Qty: 24 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev: A New Issue 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total : 1.7640 f(s)

D2423 Lug Extrusion

Batch: B23774

5.6

06/05/08

48

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blank to .850"

5.6

06/05/08

48

3.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: 1199

Machine D3394-3 as per Dwg D3394

06/05/09

(48)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK



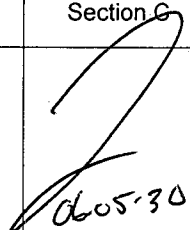

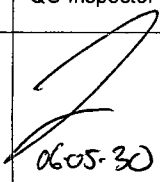
06-05-30 (46)

48 06/05/09 49 (P10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0605-30	5	3 lugs have deep deburring causing a .050 deep crater in the .453.		Notify supplier to not to crack the holes, or change. scrap 3 lugs from production denote to eng. lab.		 0605-30	 0605-30	 0605-30

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26945

Part Number: D3394043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

FF 06-05-30  
M.F. 06-05-30

46  
46

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/05/30

46

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/05/31

46

9.0 MS3548993 GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35489-93 Grommet M19620

SB 06/05/31

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3394

M.F. 06-05-31

46

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 06/05/31 x 46

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 73

06/05/01

46

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

06/06/02

46

Job Completion



M 06-06-02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

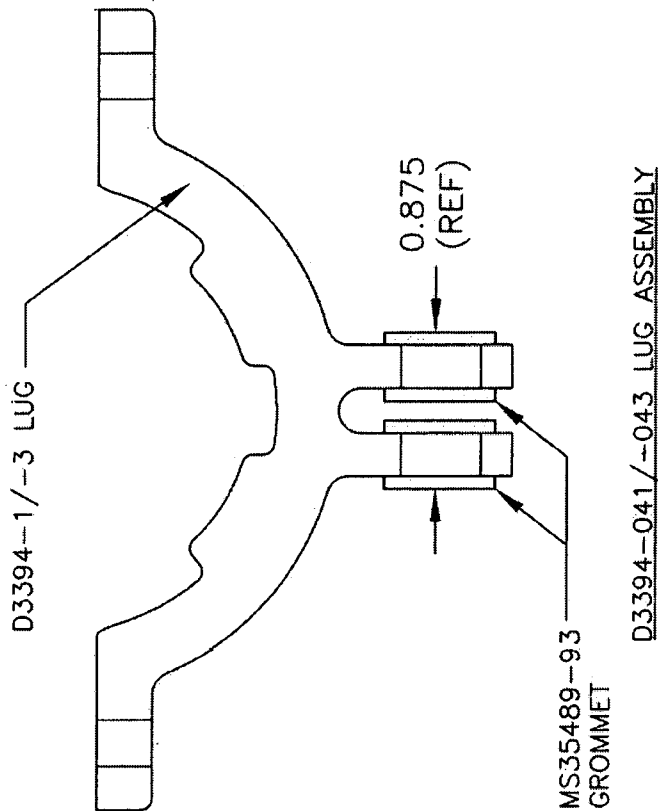
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED AH	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	

**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

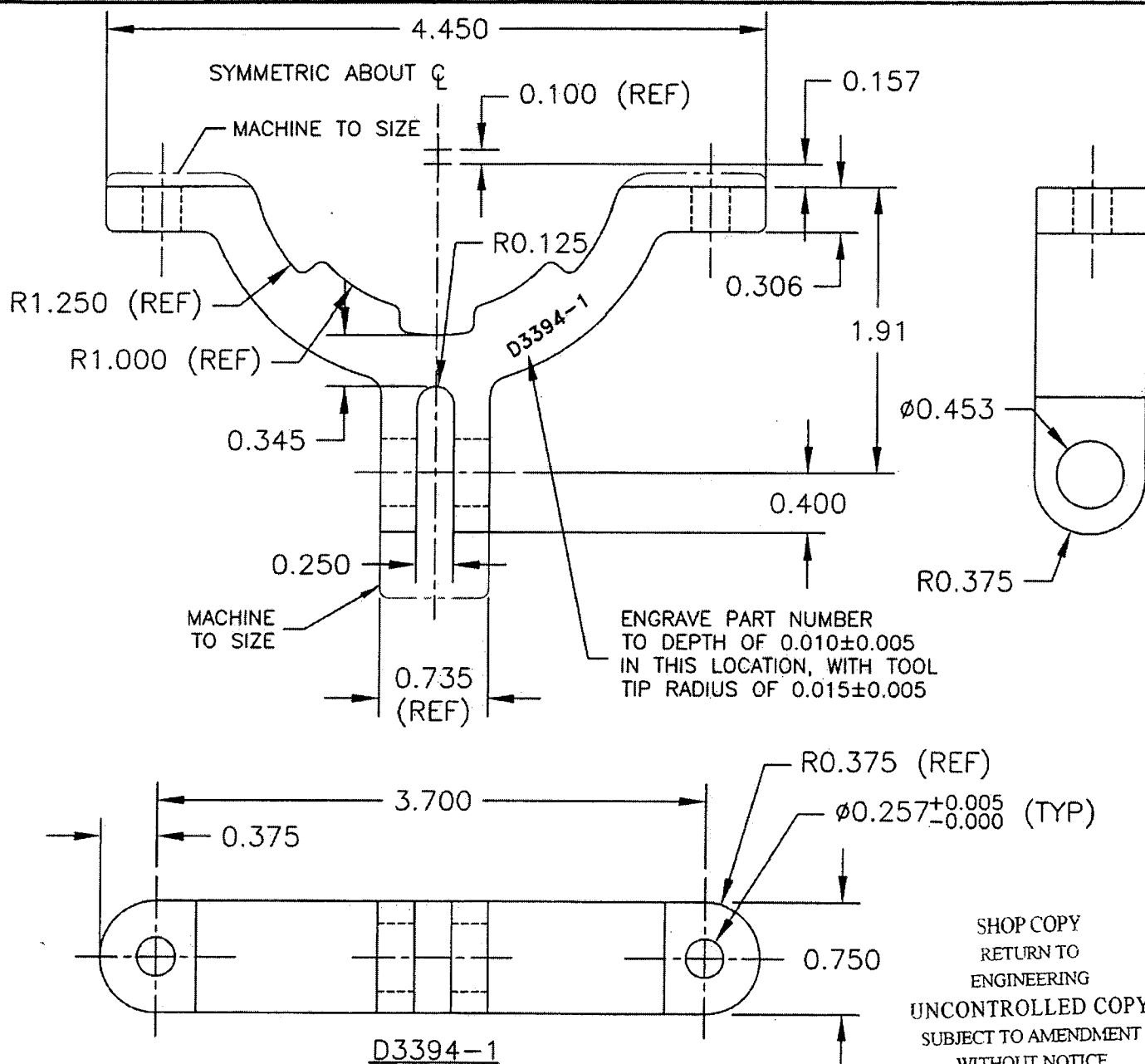
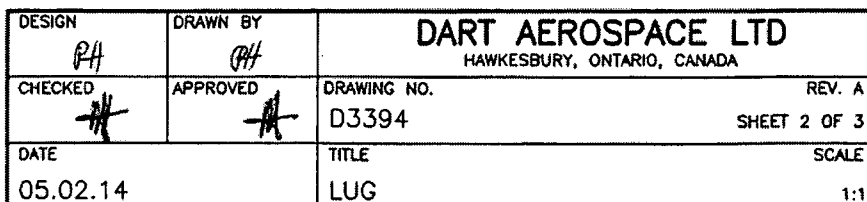
QTY -		QTY -	PART NUMBER	DESCRIPTION
041	043		D3394-041	LUG ASSEMBLY
X		X	D3394-043	LUG ASSEMBLY
			D3394-1	LUG
1		1	D3394-3	LUG
2		2	MS35489-93	GROMMET

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05.11.14

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- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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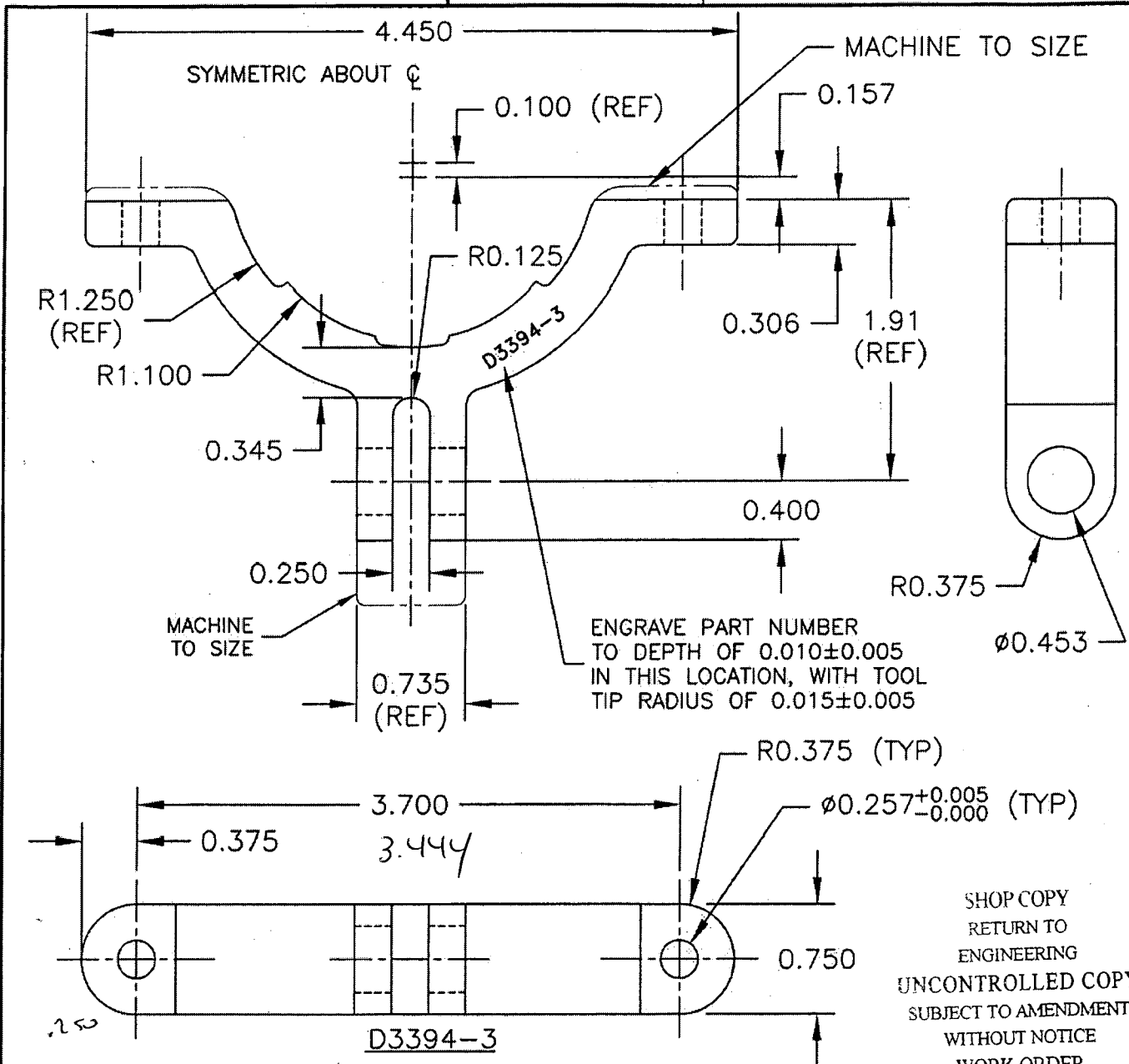
05-11-14

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**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14	TITLE LUG	SCALE 1:1	

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

49

D33943

Lug

P.O. NUMBER

1199

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, May 29, 2006

AP  
06/05/29

